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D2052
Job Sheet 200108



Part No: D2052

Part Name: Bracket

Part Weight: 0 lbs

Job Created: 9/6/19

Due Date: 10/4/19

Type: Stock

Note: DWG REV D IPP C 01.08.21 Added Finishing SM (Issue this IPP with part number D2053) IPP Rev:D now water jet 07-10-25 DD IPP Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC

Ship Via:

Job Qty: 16 pcs

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		10/4/19	0.17	0.74	Waterjet - Flow		on 20/01/07
110	QC 2	16 pcs		10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/01/07
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

PRIORITY

120 QC 8	16 pcs	10/4/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130 Small Fab - Brake NC - B4B	16 pcs	10/4/19	0.25 0.38	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JAN 07 2020 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	JAN 09 2020
140 QC 5	16 pcs	10/4/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JAN 09 2020 40 9-89
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	16 pcs	10/4/19	0.00 0.33	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JAN 10 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

Plex 9/6/19 1:10 PM Dart.lajeunesse.marie

					Handfinish - 1 - 6 - B4B					
					Handfinish - 1 - 7 - B4B					
					Handfinish - 1 - 8 - B4B					
					Handfinish - 1 - 9 - B4B					
					Handfinish - 1 - 10 - B4B					
					Handfinish - 1 - 11 - B4B					
					Handfinish - 1 - 12 - B4B					
					Handfinish - 1 - 13 - B4B					
					Handfinish - 1 - 14 - B4B					
					Handfinish - 1 - 15 - B4B					
					Handfinish - 1 - 16 - B4B					
					Handfinish - 1 - 17 - B4B					
					Handfinish - 1 - 18 - B4B					
					Handfinish - 1 - 19 - B4B					
					Handfinish - 1 - 20 - B4B					
					Handfinish - 1 - 21 - B4B					
					Handfinish - 1 - 22 - B4B					
					160 Powdercoat - 4 Black Sand - B4B	16 pcs	10/4/19	0.00 0.12	Powdercoat - 1 - B4B	
									Powdercoat - 2 - B4B	
									Powdercoat - 3 - B4B	BY 20-01-10.
									Powdercoat - 4 - B4B	
					170 QC 3	16 pcs	10/4/19	0.00 0.00	QC 3 - 10	
QC 3 - 13										
QC 3 - 15										
QC 3 - 17										
QC 3 - 18										
QC 3 - 2										
QC 3 - 28										
QC 3 - 3										
QC 3 - 30										
QC 3 - 34										
QC 3 - 36										
QC 3 - 41										
QC 3 - 51										
QC 3 - 58										
QC 3 - 59										
QC 3 - 68										
QC 3 - 9										
QC 3 - 40	JAN 10 2020 DAS 80									
QC 3 - 19	D-SC									
QC 3 - 43										
QC 3 - 24										
QC 3 - 61										
QC 3 - 81										
180 Packaging 3-1 - Stock - B4B	16 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B						
				Packaging 3 - 2 - B4B						
				Packaging 3 - 3 - B4B	5A116 DAS 80					
				Packaging 3 - 4 - B4B	9.89					
				Packaging 3 - 5 - B4B	JAN 10 2020					
					Plex 9/6/19 1:10 PM Dart.lajeunesse.marie					

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	18	16 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	✓
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-02

Part Op 100 - 1-Cut as per Dwg D2052 Prog Rev: D ****grain direction along 3.878" ****

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - Form as per Dwg D2052 using CNC Brake
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (Black Sand (Ref:4.3.5.7) per QSI005 4.3), START TIME: 8:40 OVEN TEMPERATURE: 225
FINISH TIME: 9:10
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____), LOCATION : GA
190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.090	5052-H32 .090 Sheet	2.0640 sf (.129 ea)	100-Waterjet - Flow - 1	FM131392

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.090	2	33	0

Part Specifications				
Specifications could not be found.				

NCR No. _____		Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Scrap ☐		Use-as-is ☐		Cross tube ☐		Eng. (Non-AW) ☐		Engineering ☐	
								Small Fab ☐		Prod. Eng. Coord. ☐		Water Jet ☐	
								Finishing ☐		Rec/Store/Packaging ☐		Supplier ☐	
								Large Fab ☐				Quality ☐	
Date : _____		Sequence #:		QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐					